

Work Order ID 64630

Thursday, December 09, 2010 1:04:58 PM



Page 1

Item ID: D2221

Accept



Setup Start



Revision ID:

Stop



Item Name: 350 Basket Base

Start Date: 12/9/2010 Start Qty: 1.00



Cust Item ID:

Required Date: 12/16/2010 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

BE

Date:

10-12-9

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2221

Rev H

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- assemble all ribs and both D2581 in DT9444 jig, weld as per dwg D2221
2- remove basket from jig and weld D3442-1 shims and D2232-3 hinges as per dwg D2221
3- tack weld mesh on basket as per dwg D2221
A/R ER316 S.S. Rod Batch: *111585*

Cpl 10.12.21

PLEASE NOTE

IF MAKING -041A OR -043A :
DRILL HOLES FOR GAS SPRING
IN D3825-041 AS PER
DSI 9473

110

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE
10.12.22

1 *φ*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D2221

Accept

Revision ID:

Item Name: 350 Basket Base

Start Date: 12/9/2010 Start Qty: 1.00

Required Date: 12/16/2010 Req'd Qty: 1.00

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start
Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC6- Inspect dimensions to drawing

0.00



QC

Memo

0.00

Quality Control

125

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing



Setup Start

Stop



Cust Item ID:

Customer:



1 BL 10-12-22

W/O:		WORK ORDER CHANGES					
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Revision ID:				Stop	
Item Name: 350 Basket Base					
Start Date: 12/9/2010	Start Qty: 1.00				
Required Date: 12/16/2010	Req'd Qty: 1.00				
Reference:					
			Cust Item ID:		
			Customer:		

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 Powdercoat Powder Coating	White Gloss(Ref:4.3.5.2) per QSI005 4.3-Steel <i>M115951</i> Memo 1- Plug holes prior to 1ST COAT: START TIME: <i>2:15</i> OVEN TEMPERATURE: <i>400°</i> FINISH TIME: <i>2:45</i> ***** 2nd coat if necessary***** 2ND COAT: START TIME: _____ OVEN TEMPERATURE: _____ FINISH TIME: _____	0.00 0.00				<i>1</i>		<i>BR 10-12-22</i>	
140 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00						<i>1</i>	<i>10/12/23</i>

W/O:		WORK ORDER CHANGES					
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Accept

Revision ID:

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Start Date: 12/9/2010 Start Qty: 1.00

Required Date: 12/16/2010 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

w/o 64628 el 11/01/03
D350-607-041

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 11/01/03

w 11/01/03

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Picklist Print

Thursday, December 09, 2010 1:05:02 PM

Page 1

Work Order ID: 64630

Parent Item: D2221

Parent Item Name: 350 Basket Base



Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:J 05.09.02 Added D3442-1 ☐ KJ/JLM
 IPP Rev:K 08-08-29 revG as per dwg DD verified by:EC
 IPP Rev:L 08-09-24 plug holes prior to powder coat DD verified by:EC
 IPP Rev:M 08-12-02 revH as per dwg DD verified by:EC IPP Rev:N
 10.06.29 added pressure wash DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2221-1 Rib		Manufactured	No			100	Each	11.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				11					
					63628			11					
D2221-5 Rib		Manufactured	No			100	Each	10.0000	2	2			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				10					
					62996			2					
					64269			8					
D2221-7 Rib		Manufactured	No			100	Each	5.0000	1	1			
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				WA				5					
					62997			1					
					63956			4					

CP 12.12.21

CP 10.12.21

CP 10.12.21

CP

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Thursday, December 09, 2010 1:05:02 PM

Page 2

Work Order ID: 64630

Parent Item: D2221

Parent Item Name: 350 Basket Base

Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 1.00

Required Qty: 1.00

D2232-3

Manufactured No

100

Each

8.0000

2



Basket Hinge

Location

Loc Qty

Loc Code

WA

8

63878

2

64270

6

D2235-1

Manufactured No

100

Each

16.0000

2



Basket Rib

Location

Loc Qty

Loc Code

WA

16

64109

6

64250

10

D2581

Manufactured No

100

Each

13.0000

2



Mounting Bracket

Location

Loc Qty

Loc Code

WA

13

61953

13

D3442-1

Manufactured No

100

Each

10.0000

2



Shim

Location

Loc Qty

Loc Code

WA

10

63002

10



Cpl 10.12.21



②
Cpl 10.12.21



②
Cpl 10.12.21



364425 → ①
①
Cpl 10.12.21

3630
②

W/O:		WORK ORDER CHANGES					
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Page 3

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Parent Item: D2221

Parent Item Name: 50 Basket Base

Start Date: 12/9/2010

Required Date: 12/16/2010

Start Qty: 1.00

Required Qty: 1.00

D3825-041

Manufactured No

100 Each

8.0000

2



Rib Assembly (Basket End)

Location

Loc Qty

Loc Code

WA

8

63425

2

64108

6

2



Cpl 10.12.21

D3826-041

Manufactured No

100 Each

2.0000

2



Rib / Gusset Assembly

Location

Loc Qty

Loc Code

WA

2

63119

2

2



Cpl 10.12.21

D3827-041

Manufactured No

100 Each

6.0000

1



Rib Assembly (Inboard)

Location

Loc Qty

Loc Code

WA

6

63959

6

1



Cpl 10.12.21

D3832-1

Manufactured No

100 Each

3.0000

1



Mesh (Base)

Location

Loc Qty

Loc Code

WA

3

63981

3

1



Cpl 10.12.21

D3833-1

Manufactured No

100 Each

6.0000

2



Mesh (Base End Face)

Location

Loc Qty

Loc Code

WA

6

63255

6

2



Cpl 10.12.21

Thursday, December 09, 2010 1:05:02 PM

Shop Packet Print

Page 3

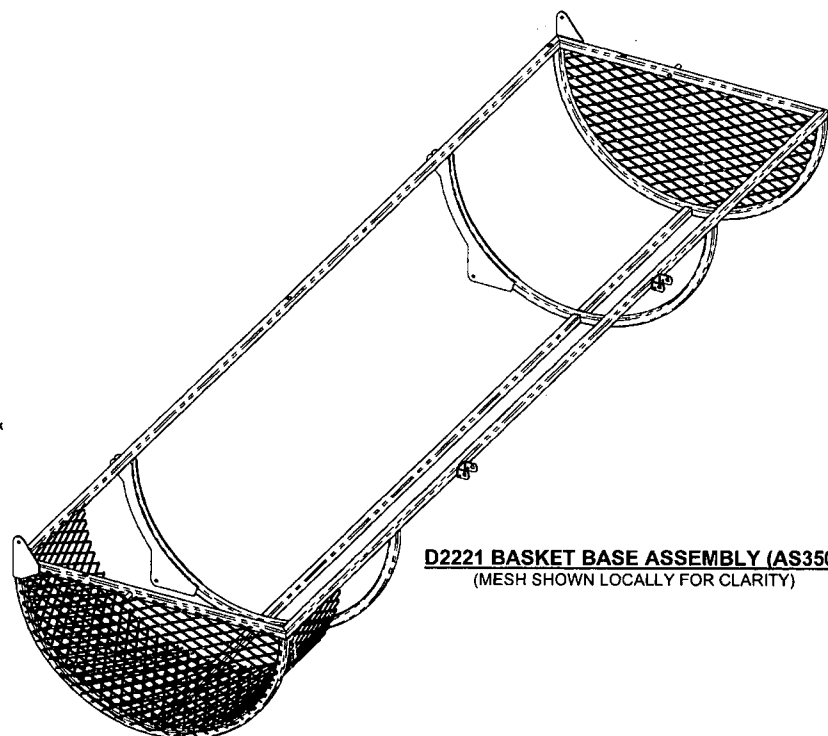
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NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (AS350)
(MESH SHOWN LOCALLY FOR CLARITY)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 8) WEIGHT: 42.00 lbs APPROX
- 9) MASK ALL HOLES PRIOR TO POWDER COATING

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 04630
P11012-9

ITEM	QTY	P/N	DESCRIPTION
1	X	D2221	BASKET BASE ASSEMBLY (AS350)
2	1	D2221-1	RIB
3	2	D222	RIB
4	1	D2221-7	RIB
5	2	D2232-3	BASKET HINGE
6	2	D2235-1	RIB
7	2	D2581	MOUNTING BRACKET
8	2	D3442-1	SHIM
9	2	D3825-041	RIB ASSY (BASKET END)
10	2	D3826-041	RIB/GUSSET ASSY
11	1	D3827-041	RIB ASSY (INBOARD)
12	2	D3833-1	MESH, BASE END FACE
13	1	D3832-1	MESH (BASE)

H	REVISED PARTS LIST AND ADDED "ITEM" COLUMN TO PARTS LIST (ZN D3-1); REVISED SECTIONS A-A, B-B AND C-C (ZN D8-3, C2-3 AND A6-3); REVISED DETAIL D (ZN B7-4); ADDED DETAIL E (ZN A6-4); ADDED SECTION F-F (ZN B2-4); ADDED DWG DETAILS FOR D2221-1/5/7 (SHEET 5); TOL REVISED TO 2 DEC PLACES (ZN D8-3 AND ZN B4-3); D3825-041 REPLACES D2221-3/D2327-3; D3826-041 REPLACES D2235-1/D2325; D3827-041 REPLACES D2221-1 ON INBOARD SIDE; ADDED D3832-1 AND D3833-1. REASON: SATISFY "LEAN MANUFACTURING" PROGRAM.	MB	08.09.18
G	MATERIAL FOR -1, -3, -5 & -7 WAS 0.060 WALL; TOLERANCE FOR 96.00 DIM WAS +/-0.01 AND 56.00 DIM WAS REF (ZN B5-2); 19.62 DIM WAS "HARD" DIMENSION IS NOW "REF" (ZN B4-2); NOTE 5 TRANSFERRED FROM SHT 1 TO SHT 2; SHT 2 MESH MATERIAL UPDATED; DRAWING TRANSFERRED TO "B" FORMAT	AJS	08.06.16
F	ADD SHIM UNDER HINGE; ADD HOLES FOR SPLIT LID BASKET	PH	05.06.07
E	CHANGE HINGE	CP	01.04.19
D	CHANGE LATCH	BW	96.06.21
C	SEPARATE BASKET AND LID	KH	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BS		
CHECKED	BS	DRAWING NO.	REV. H
MFG. APPR.	BS	D2221	SHEET 1 OF 5
APPROVED	BS	TITLE	SCALE
DE APPR.	BS	BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	<small>COPYRIGHT © 1994 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD</small>	

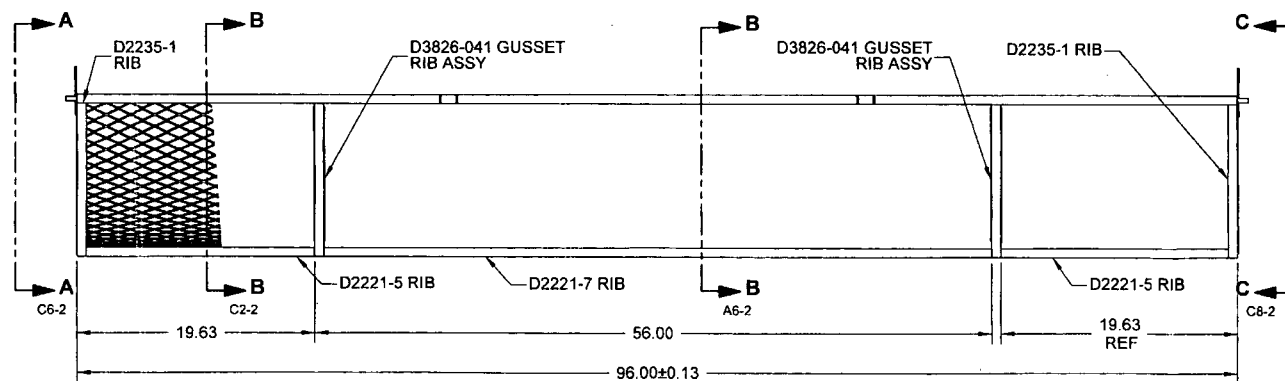
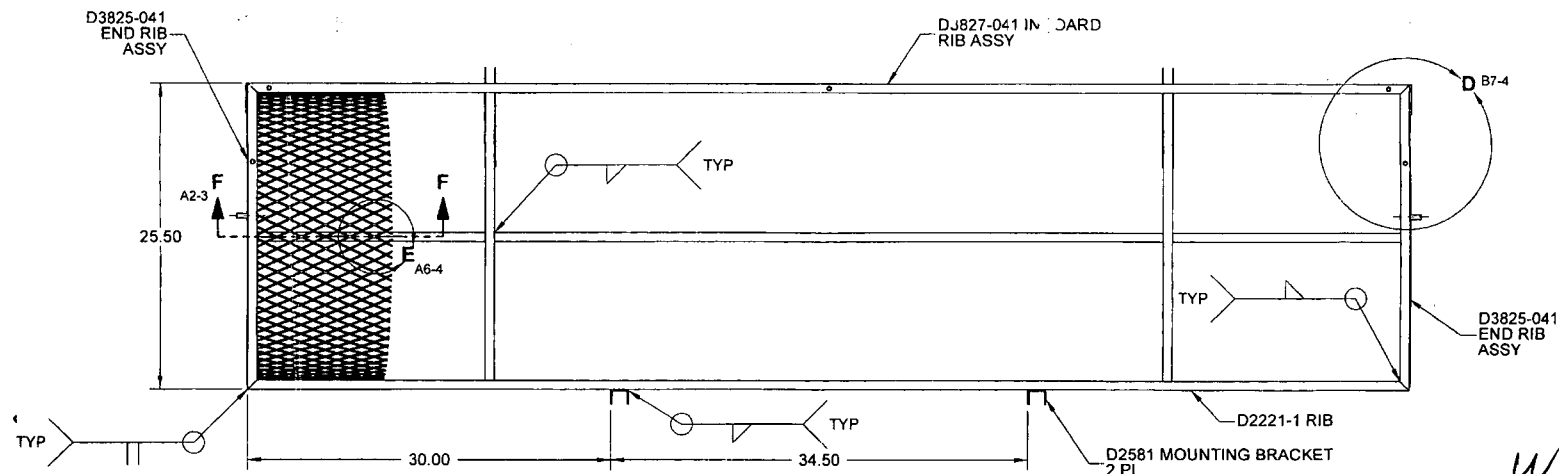
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____



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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D2221 BASKET BASE ASSEMBLY (350)
(MESH SHOWN LOCALLY FOR CLARITY)

RELEASED
06/11/18 JND

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 2 OF 5
APPROVED		TITLE	SCALE
DE APPR.		BASKET BASE ASSEMBLY (350)	NTS
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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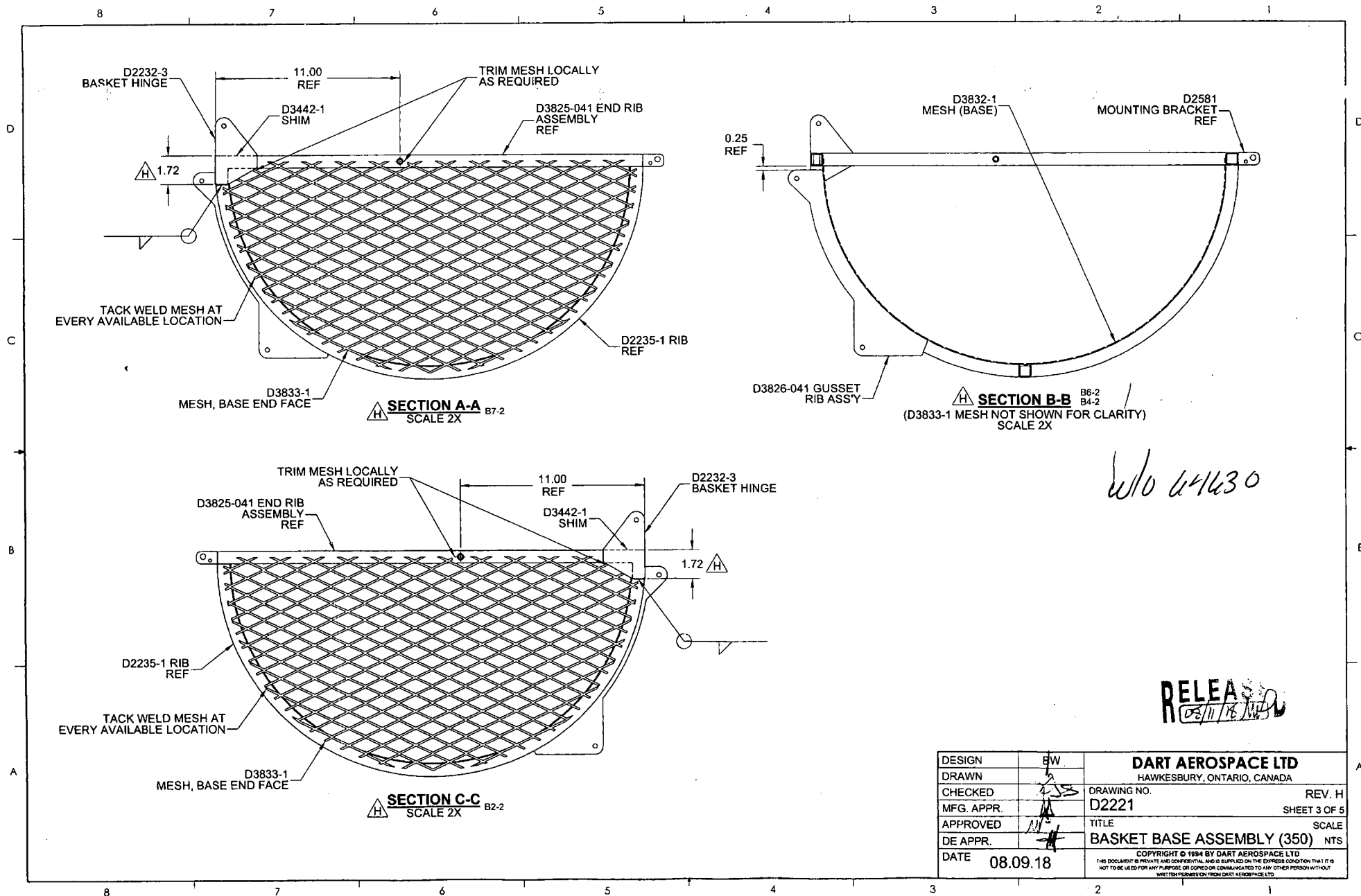
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DESIGN	BW	DART AEROSPACE LTD	
DRAWN	2	HAWKESBURY, ONTARIO, CANADA	
CHECKED	2	DRAWING NO.	REV. H
MFG. APPR.		D2221	SHEET 3 OF 5
APPROVED	11	TITLE	SCALE
DE APPR.	#	BASKET BASE ASSEMBLY (350) NTS	
DATE	08.09.18	COPYRIGHT © 1994 BY DART AEROSPACE LTD	
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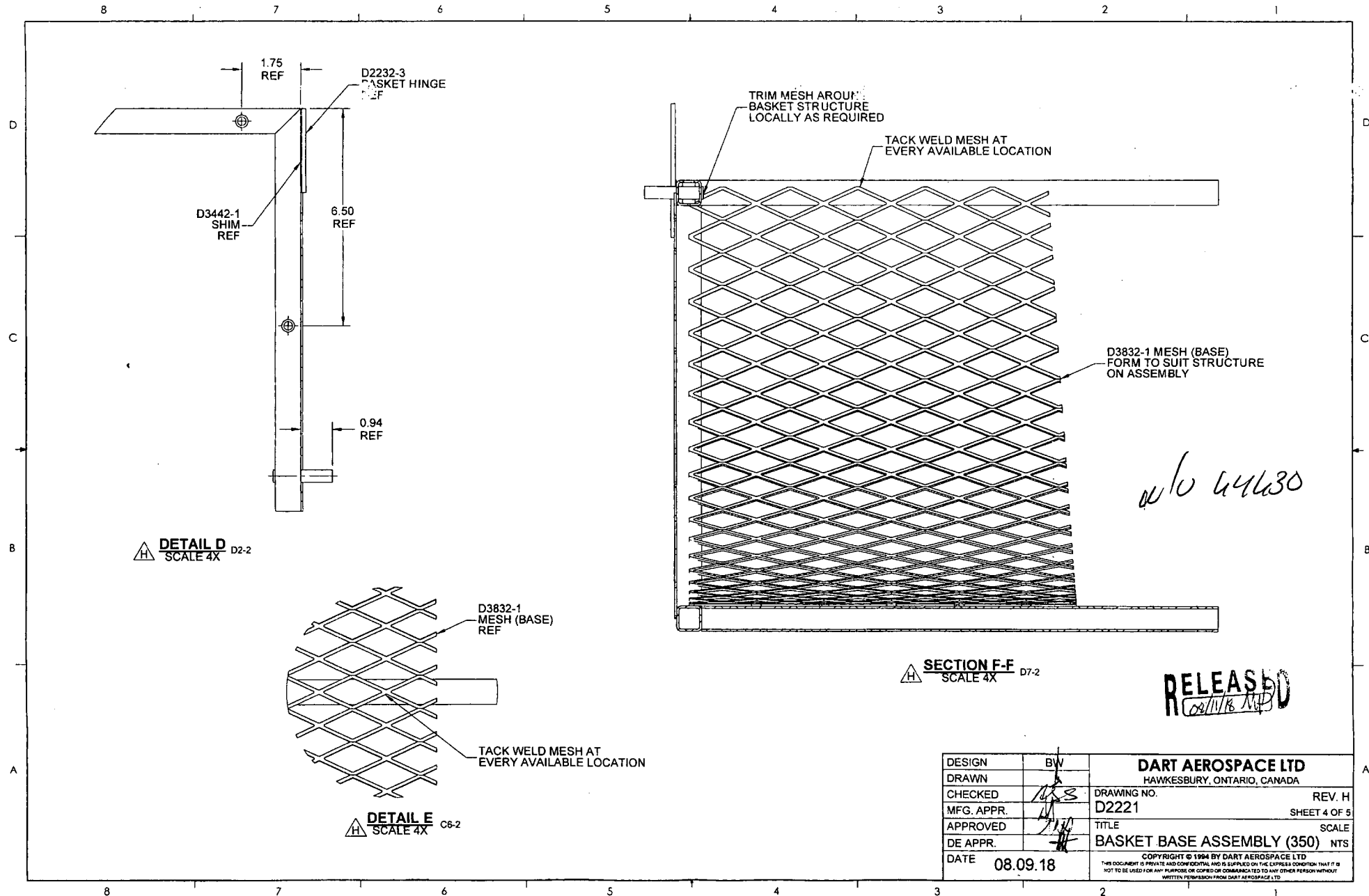
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DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>[Signature]</i>	D2221	SHEET 4 OF 5
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	BASKET BASE ASSEMBLY (350) NTS	
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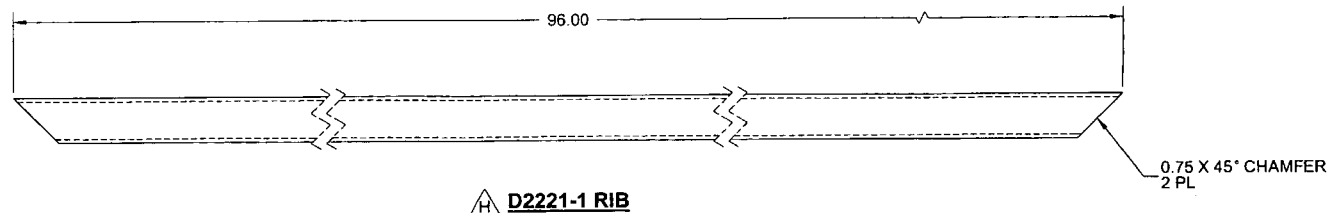
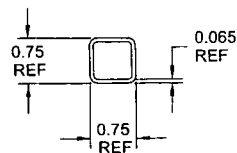
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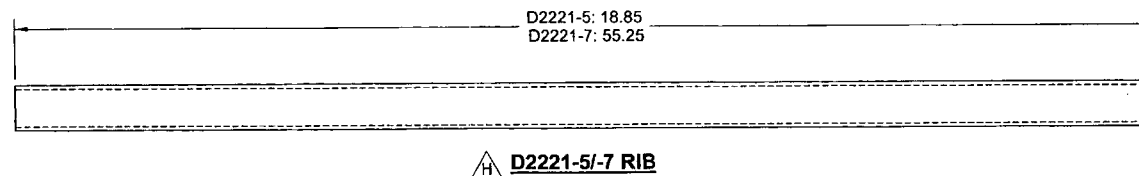
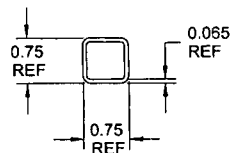
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W/C 44630



RELEASED
08/11/18 WJ

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 8) WEIGHT: D2221 -1 = 4.57 lbs; D2221-5 = 0.90 lbs; D2221-7 2.65 = lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>AS</i>	DRAWING NO.	REV. H
MFG. APPR.	<i>MD</i>	D2221	SHEET 5 OF 5
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	BASKET BASE ASSEMBLY (350)	NTS
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